

Date: Monday, 05/02/2007 2:28:27 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET PLATE
Job Number : 30630	
Estimate Number : 10199	
P.O. Number : <i>N/A</i>	Part Number : D2179
This Issue : 05/02/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2179 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30630	Material : <i>N/A</i>
Written By : _____	Due Date : 22/02/2007 Qty: 60 Um: Each
Checked & Approved By : _____	
Comment : Est A 00.07.17 New Issue EC -Est Rev:B Now on Waterjet 07-02-05 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0096 sf(s)/Unit Total : 0.5733 sf(s)
 Material: 5052-H32 (or 6061-T6) 0.040" thick
 (M5052H32S.040) Batch: *M101875 ml 07 02 28* (60)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2179
 Dwg Rev: *B ml 07 02 28* (60)
 Prog Rev: *B*

2-Deburr if necessary

ghm 07/03/07 (60)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE *ml 07 02 28* (60)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK *07/03/01* (60)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1 *m-l 07/03/08* (60x)

Date: Monday, 05/02/2007 2:28:27 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M/103141



60x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.H

07/03/08

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

~~07/03/08~~ 60

07/03/08

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/08 60

U

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/09

Job Completion



U 07-03-09

2

Date: Monday, 2/5/2007 8:14:56 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET PLATE
Job Number	: 30630		
Estimate Number	: 10199		
P.O. Number	:	Part Number	: D2179
This Issue	: 2/5/2007	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2179 REV. B
First Issue	: 1 /	Project Number	: N/A
Previous Run	: 26077	Drawing Revision	: B
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 2/9/2007
Checked & Approved By	:	Qty:	60 Um: Each
Comment	: Est A 00.07.17 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.0096 sf(s)/Unit Total : 0.5733 sf(s)
Material: 5052-H32 (or 6061-T6) 0.040" thick
(M5052H32S.040) Batch: _____

2.0	SHEAR	SHEAR
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Comment: SHEAR
Cut blank: 1.645" x 0.800"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA080 and Dwg D2179
Identify as D2179

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble and Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:14:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET PLATE

Job Number: 30630

Part Number: D2179

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 07/03/09
 QA: N/C Closed: _____ Date: _____

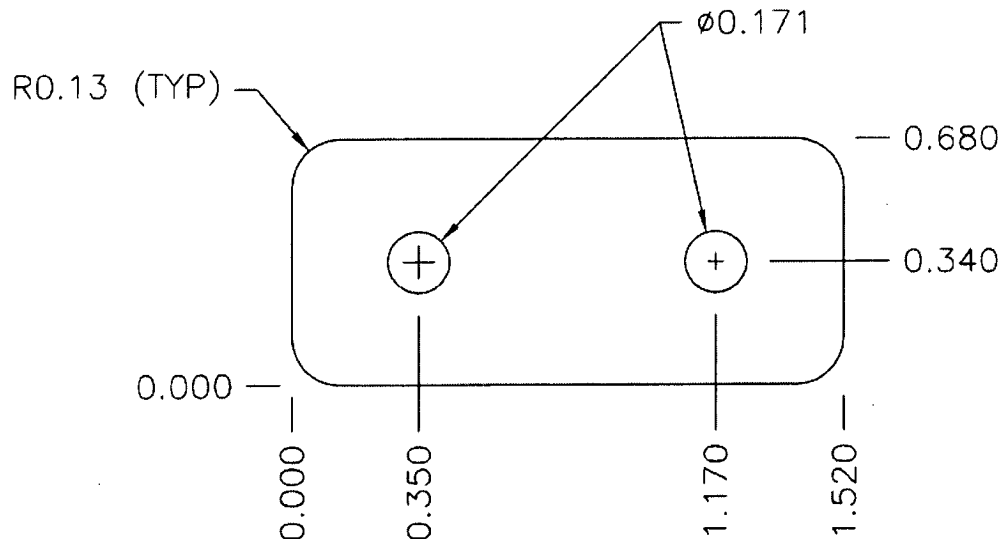
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KH	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2179	REV. B SHEET 1 OF 1
DATE 00.06.20		TITLE HINGE BRACKET PLATE	SCALE 2:1
A	95.03.17	NEW ISSUE	
B	00.06.20	DWG No. D2179 WAS D2399	

RELEASED
00.06.27



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11)
OR 2024-T3 (QQ-A-250/4) 0.040 THICK

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30630

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